

Work Order ID 62459

Thursday, September 30, 2010 12:42:56 PM

Page 1

Item ID: D3536-15

Accept

Revision ID:

Item Name: Gasket

Start Date: 9/30/2010 Start Qty: 8.00

Required Date: 10/8/2010 Req'd Qty: 8.00

Reference:

Approvals:

Process Plan:

Date: 10/9/30

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3536

Rev A

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

10-10-4

(11)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

10-10-4

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

8.10.10.05

(HL)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62459

Thursday, September 30, 2010 12:42:56 PM



Page 2

Item ID: D3536-15

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 9/30/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 10/8/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: PP

0.00



Packaging

Memo

0.00

Packaging

11/16 SP 110

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/06 MF
10-10-06

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Picklist Print

Thursday, September 30, 2010 12:43:01 PM

Page 1

Work Order ID: 62459



Parent Item: D3536-15



Parent Item Name: Gasket

Start Date: 9/30/2010

Required Date: 10/8/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MNEO60S.063

Purchased

No

100

sf

415.0353

0.9848

8.293053

10.9



B10-10-4

NEOPRENE SHEET 0.063

Location

Loc Qty

Loc Code

MAT

309.7822

114691

105.9602

115500

203.822

MAT052

105.2531

114176

105.2531

115500

(11)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	62459
Description: Gasket		Part Number:	D3536-15
Inspection Dwg: D3536	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.15	+/-0.030	39.15	u		T B01	
35.65	+/-0.030	35.65	~		T	
33.65	+/-0.030	33.65	u		T	
30.15	+/-0.030	30.15	u		T	
24.90	+/-0.030	24.90	u		T	
19.65	+/-0.030	19.65	u		T	
14.40	+/-0.030	14.40	u		T	
9.15	+/-0.030	9.15	u		T	
5.65	+/-0.030	5.65	u		V B02	
3.90	+/-0.030	3.901	u		V	
8.00	+/-0.030	8.00	u		T	
16.00	+/-0.030	16.00	u		T	
24.00	+/-0.030	24.00	u		T	
0.30	+/-0.030	.301	u		V	
0.30	+/-0.030	.301	u		V	
1.89	+/-0.030	1.890	u		V	
Ø0.19	+0.005/-0.001	.190	u		V	

Measured by:	B	Audited by:	E	Prototype Approval:	N/A
Date:	10-10-4	Date:	10/10/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

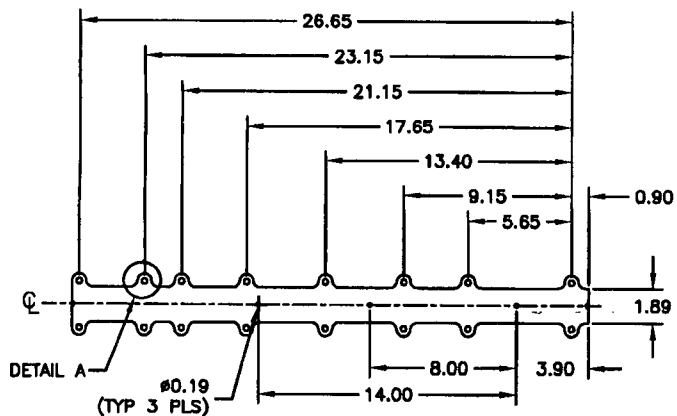
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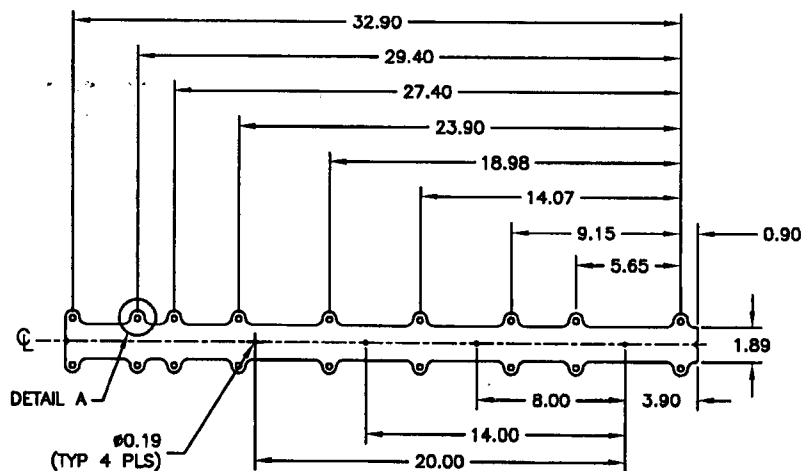
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RELEASED
09.02.12

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *62459*
PS10-9-30



D3536-11 GASKET



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	CB	PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3536	REV. A
DATE 06.10.25	TITLE GASKET	SHEET 1 OF 6	
A	06.10.25	NEW ISSUE	SCALE 1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

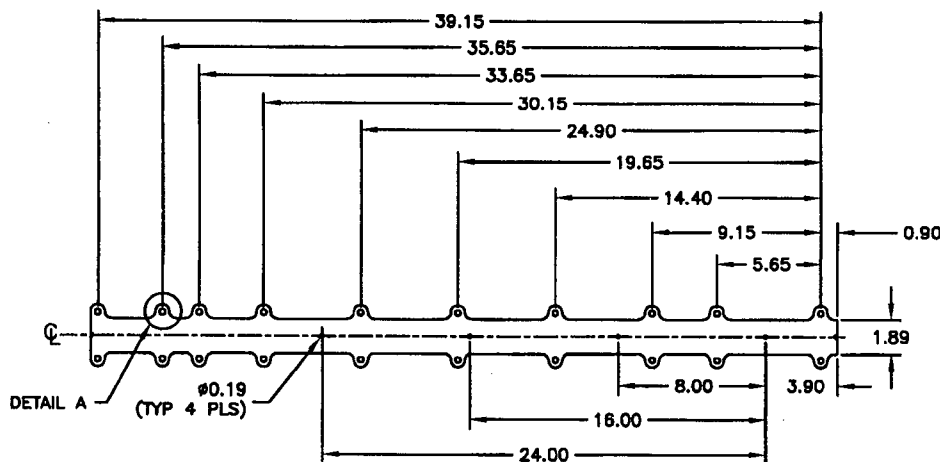
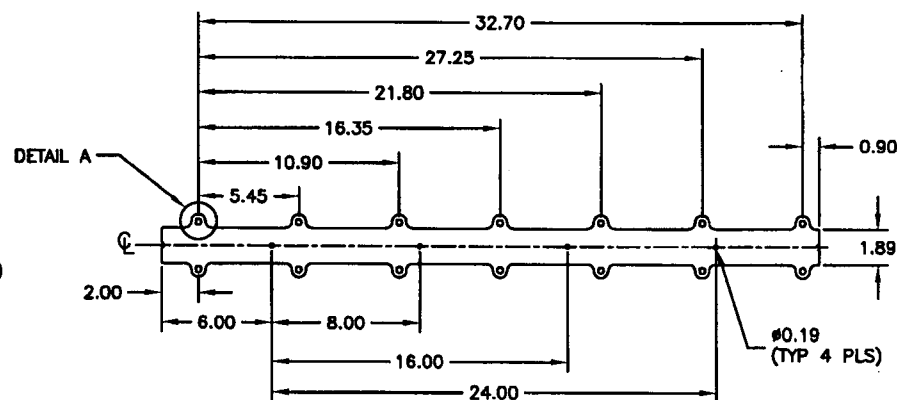
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DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 2 OF 6
		SCALE	1:10	

RELEASED

07.02.12

w/o 62459

**D3536-15 GASKET****D3536-21 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

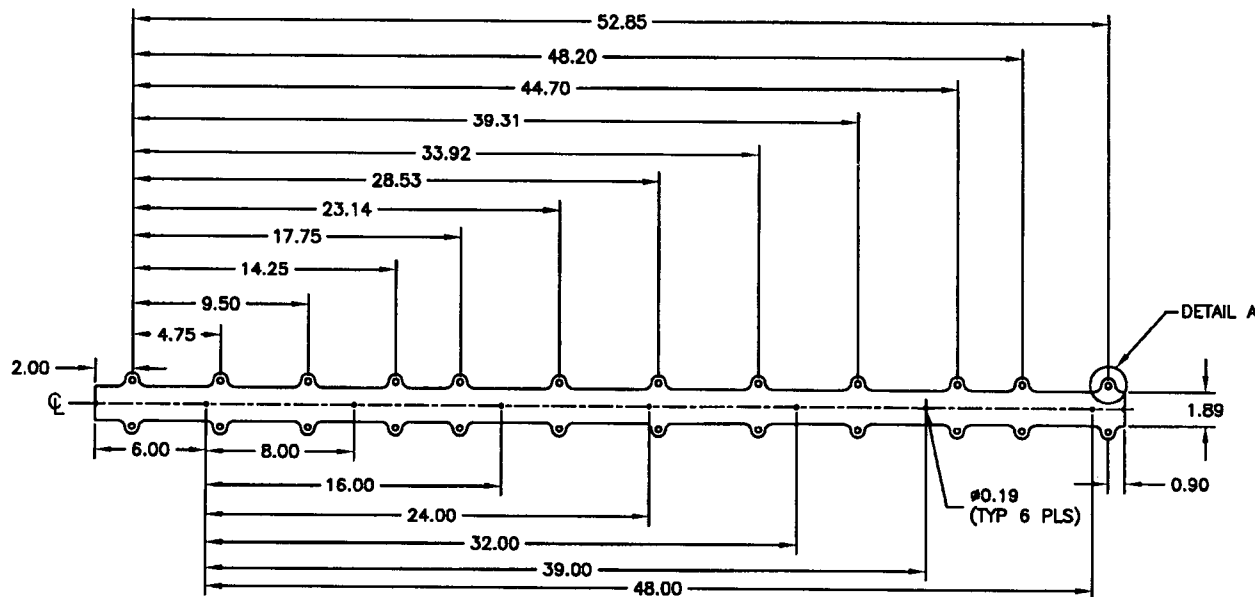
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

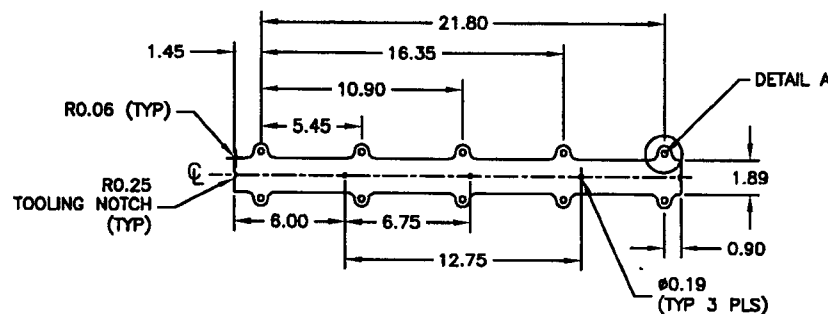
u/o 62459

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RELEASED
070212



D3536-23 GASKET



D3536-25 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
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DATE	06.10.25	DRAWING NO.	D3536	REV. A
TITLE	GASKET	SHEET	3 OF 6	SCALE
				1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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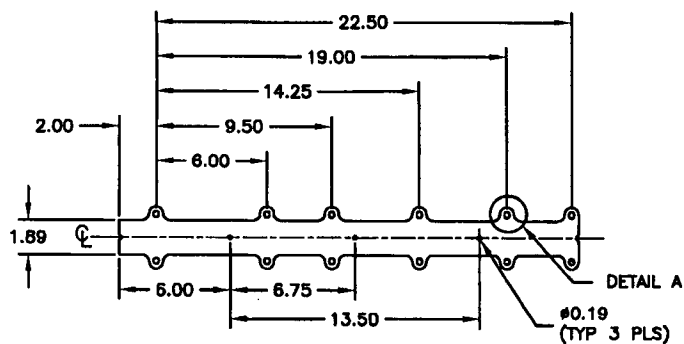
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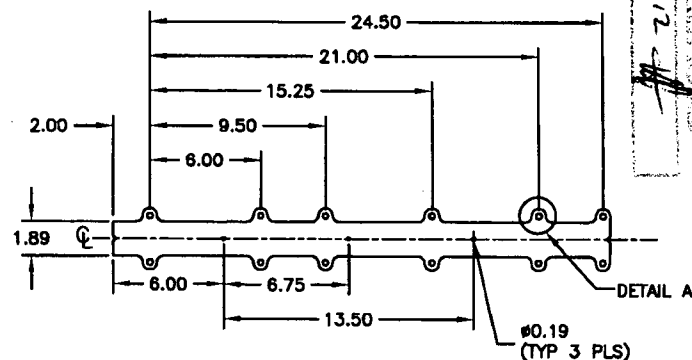
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CHECKED	PH	APPROVED	PH	
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REV. A		SHEET 4 OF 6	SCALE	
		1:10		

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07.02.12

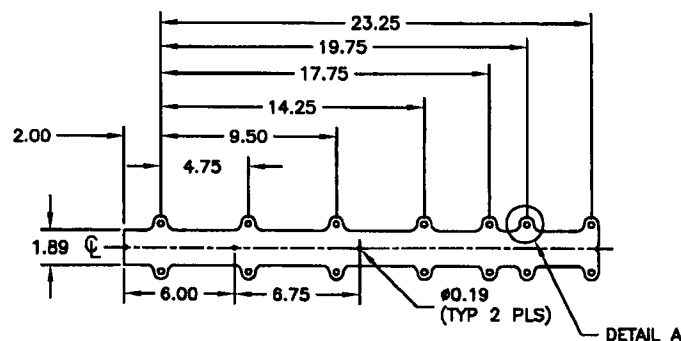
w/b 42459



D3536-31 GASKET



D3536-33 GASKET



D3536-35 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

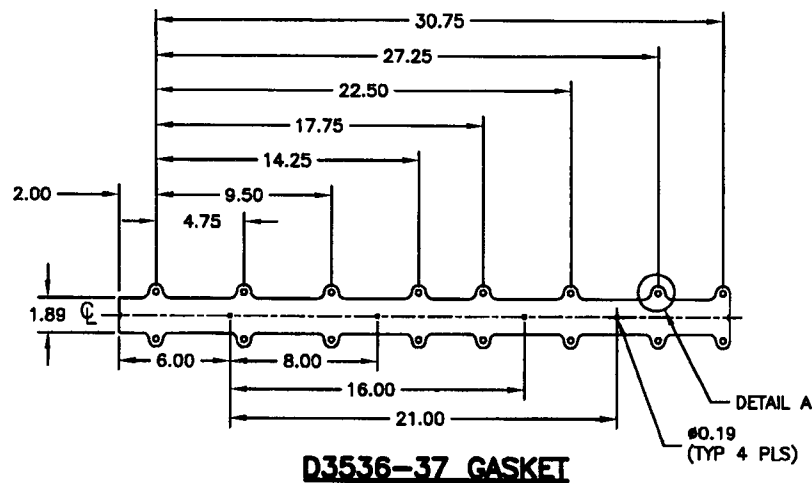
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DART

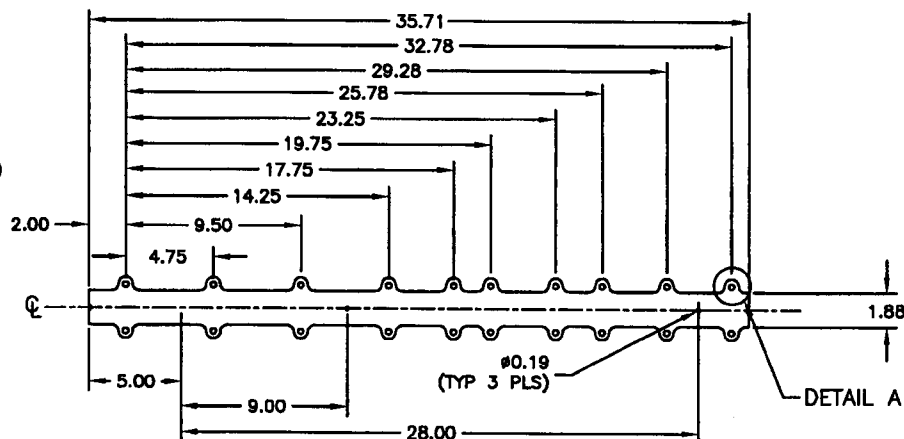
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DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 5 OF 6
				SCALE 1:10

07.02.12
07.02.12
07.02.12

celo 42459



D3536-37 GASKET



D3536-39 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE080-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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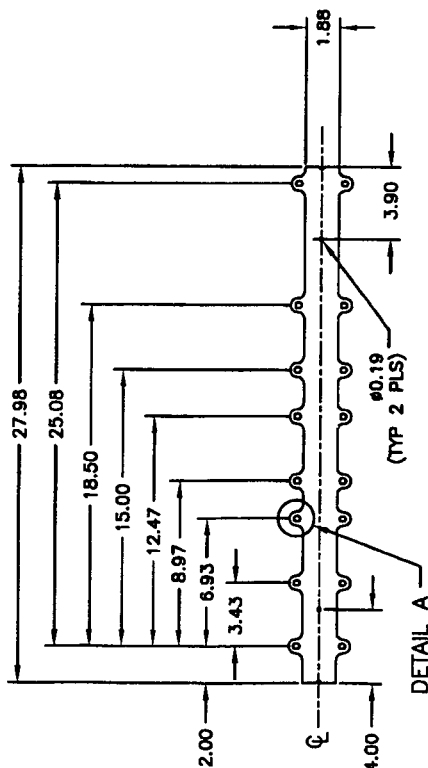
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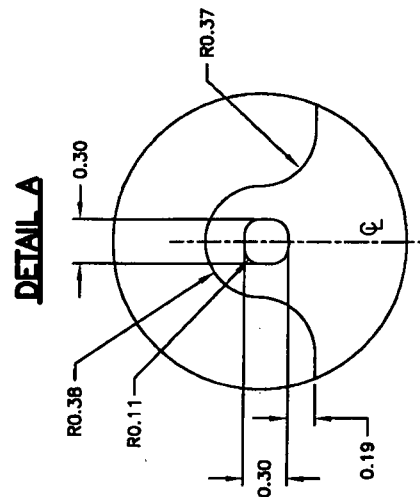
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DATE 06.10.25		TITLE GASKET	SCALE 1:10

07.02.12

65459



D3536-41 GASKET



NOTES

- (1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S-083)
- (2) FINISH: NONE
- (3) PART IS SYMMETRICAL ABOUT ϕ
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